

Work Order ID 73946

Tuesday, September 20, 2011 9:27:14 AM

Page 1

Item ID: D412-698-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Panel Automatic Door Opener, RH (Standard)

Start Date: 9/20/2011 Start Qty: 1.00

Required Date: 10/4/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MF*Date: *11-09-20*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9548

A

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPD412-698-042 CHG001

0.00

0.00

110



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

SCRAP*8/10/13**11/9/2011**(H)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73946



Page 2

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Sequence ID/
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DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-042

Location: _____

PPP rev: _____

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

close at 0
used for testing
see Russ
remaining STK pulled on 0700 Nov

CME 11-10-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 73946

Parent Item: D412-698-042

Parent Item Name: Hinge Panel Automatic Door Opener, RH (Standard)









Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.08.18 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-21  Door Prop		Manufactured	No			110	Each	1.0000	1	1			
 373948 <i>sf</i>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST			1						
				68168			1						
D3622-1  Ball Stud		Manufactured	No			110	Each	29.0000	1	1			
 <i>sf</i>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST070			29						
				72102			29						
D4330-042  Airframe Bracket Assembly, RH		Manufactured	No			110	Each	0.0000	1	1			
 373950 <i>11/9/29</i>													
D4330-3  Door Bracket		Manufactured	No			110	Each	1.0000	1	1			
 373951 <i>11/9/29 sf</i>													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				Eagle			1						
				67384			1						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73946



Parent Item: D412-698-042



Parent Item Name: Hinge Panel Automatic Door Opener, RH (Standard)

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

110

Each

1,287.000

1



Nut



[Handwritten signature]

Location

Loc Qty

Loc Code

ST300

1287

116105

5

116548

53

117441

343

117611

90

118179

496

118910

300

NAS1149D0563J

Purchased

No

110

Each

4,777.000

1



Washer



[Handwritten signature]

Location

Loc Qty

Loc Code

ST298

4777

118206

3777

118614

1000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Sequence ID/
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Operation
Description

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Packaging

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Memo

0.00

0.00

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

M.L. 26-09-2011

REFERENCE ONLY

5.0 WEIGHT & BALANCE:

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-698-041 LH (Standard)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kG	86.27 in 2.19 m	19.84 in-lb 0.22 m-kG
D412-698-042 RH (Standard)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kG	86.27 in 2.19 m	19.84 in-lb 0.22 m-kG
D412-698-043 LH (Spacedoor™)	0.23 lb 0.10 kg	-43.63 in -1.11 m	-10.03 in-lb -0.11 m-kG	86.27 in 2.19 m	19.84 in-lb 0.22 m-kG
D412-698-044 RH (Spacedoor™)	0.23 lb 0.10 kg	43.63 in 1.11 m	10.03 in-lb 0.11 m-kG	86.27 in 2.19 m	19.84 in-lb 0.22 m-kG

6.0 PARTS LIST:

Qty -041	Qty -042	Qty -043	Qty -044	Part Number	Description
X				D412-698-041	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (STANDARD)
	X			D412-698-042	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (STANDARD)
		X		D412-698-043	HINGE PANEL AUTOMATIC DOOR OPENER KIT, LH (SPACEDOOR™)
			X	D412-698-044	HINGE PANEL AUTOMATIC DOOR OPENER KIT, RH (SPACEDOOR™)
1	1	1	1	D3552-21	GAS SPRING
1	1	1	1	D3622-1	BALL STUD
1		1		D4330-041	AIRFRAME BRACKET ASSEMBLY, LH
	1		1	D4330-042	AIRFRAME BRACKET ASSEMBLY, RH
1	1	1	1	D4330-3	DOOR BRACKET
		3	3	80-005-2-8	INSERT
1	1	1	1	MS21042L5	NUT
		3	3	MS27039-1-05	SCREW
		3	3	NAS1149D0332J	WASHER
1	1	1	1	NAS1149D0563J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: MS
D. SHEPHERD (DE # 02)

DATE: 11.04.26
CERT. NO.: SH92-43
ISSUE NO.: 5

DESIGN	<u>DL</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>DL</u>		
CHECKED	<u>DL</u>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9548	SHEET 8 OF 8
APPROVED	<u>DL</u>	TITLE	SCALE
DE APPR.	<u>DL</u>	HINGE DOOR OPENER KIT	NTS
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